



NO. 41300
A
WORK ORDER
WITHOUT NOTICE
ENGINEERING
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

ORIGINAL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41366

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (F2)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CALL welding S 08/10/23 (F2)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23 (F2)

Job Completion



mr 08-10-23

Dart Aerospace Ltd

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Job Number: 41366

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320
9:30

m-l

(2X)
08/09/30

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



jd



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-30 (X2)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

90 Degree Cover Plate

batch: 41518 x4.

Cpl 08.10.22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-83

batch: 41516

Cpl 08.10.22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Screw

batch: m109031

Cpl 08.10.22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

WASHER

batch: m109031

Cpl 08.10.22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

Cpl 08.10.22

(X4) (X2)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41366

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Pl 08.09.29 (X2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 08-09-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/29 (X2)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELICAL INSERT

3 M11935

Pl 08.09.29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

Pl 08.09.29
Pl 08.09.29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/09/29 *S 08/09/29* (X2)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

u/a S 08/09/30

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M102316

(2X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M. 08/09/30

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 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY
 Job Number : 41366
 Estimate Number : 13436
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : PB674300113
 First Issue : / / Drawing Number : B6743001 P.8
 Previous Run : 40607 Type : LARGE FAB ASSY Project Number : N/A
 Material : B1
 Due Date : 18/09/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : JULIE LECOCQ
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001255 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inner Tube

batch: 341484

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inner Tube Bushing

batch: 118147

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Gusset

batch: 340717 41492

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Gusset

batch: 340053 41493

5.0 PB674300167 PB67-43001-67



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-67

batch: 341214